

Date: Wednesday, 4/5/2006 3:29:46 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
<b>Job Number</b>	: 26562		<b>Part Number</b>	: D2573		
<b>Estimate Number</b>	: 10533		<b>Drawing Number</b>	: D2573 REV E		
<b>P.O. Number</b>	: N/A		<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 4/5/2006	<b>S.O. No.</b>	: N/A	<b>Drawing Revision</b>	: E	
<b>Prsht Rev.</b>	: NC	<b>Type</b>	: MACHINED PARTS			
<b>First Issue</b>	: N/A		<b>Material</b>	: N/A		
<b>Previous Run</b>	: 26498		<b>Due Date</b>	: 4/24/2006		Qty: 4 Um: Each
<b>Written By</b>	: <i>Stg</i>		<b>Comment Below</b>			
<b>Checked &amp; Approved By</b>	: <i>RJ</i>		06.04.06			
<b>Comment</b>	: Est: 1 As Per RevE 06-01-27 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <i>321902</i>	<i>E/K.G 06/05/02 x4</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>26562</i> Double check by: <i>SD</i>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>J.G/SD 06/05/02 x4</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<i>E/K.G 06/05/02 x4</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>J.G/E/K.G 06/05/02 x4</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:29:47 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26562

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



SD 06.05.08 4

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



SAD 06.05.09 ④

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



POWDER COATING 06-05-09 ④

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



FC 06.05.09 ④

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1 06-05-09 ④

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST480

R 06/05/10 4

10.0 DC DOCUMENT CONTROL



DOCUMENT CONTROL 06/05/11 ④

Comment: DOCUMENT CONTROL

Inspection Level 21

U 060511 ④

Job Completion



060511 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	26562
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.749	1.747	1.747		
C	3.495	3.505		3.498	3.497	3.500	3.501		
D	1.745	1.755		1.746	1.749	1.747	1.747		
E	7.990	8.010		8.002	8.005	8.005	8.005		
F	0.490	0.510		0.502	0.493	0.497	0.493		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.375	0.375	0.375		
I	0.490	0.510		0.502	0.499	0.501	0.497		
J	1.174	1.184		1.178	1.175	1.175	1.175		
K	0.558	0.578		0.569	0.563	0.569	0.562		
L	1.174	1.184		1.177	1.175	1.175	1.175		
M	1.365	1.375		1.369	1.366	1.365	1.367		
N	2.495	2.505		2.501	2.498	2.496	2.495		
O	4.119	4.129		4.119	4.122	4.121	4.122		
P	0.115	0.135		0.121	0.121	0.122	0.120		
Q	0.115	0.135		0.120	0.135	0.135	0.135		
R	0.240	0.260		0.243	0.250	0.252	0.251		
S	0.115	0.135		0.122	0.121	0.118	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.232	3.230	3.230		
V	0.230	0.250		0.241	0.230	0.234	0.235		
W	0.115	0.135		0.119	0.126	0.127	0.127		
X	0.308	0.313		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.371	0.367	0.362	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.633	0.633	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.241	0.245	0.243		
AE	1.500	1.520		1.508	1.512	1.513	1.510		
AF	0.115	0.135		0.132	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.244	0.248	0.248	0.249		
AI	2.000	2.020		2.000	2.002	2.003	2.000		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by:	3-G/JP	Audited by:	JL
Date:	06/05/05	Date:	06/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ JLM ✓



